Al .750

8

Work Order ID 81967

March-21-12 1:50:33 PM

81967

Item ID: D3492-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Plug

Start Date: 21/03/2012 **Start Qty:** 100.00 *100*

Required Date: 04/04/2012 **Req'd Qty:** 100.00 *100*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 12/03/21 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3492 / D									
100		0.00							
100 Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** 1-Turn as per Folio FA632 & Dwg D3492 Dwg Rev:_____ Folio Rev:_____	0.00				100	ϕ		BC 12.04.04
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC Quality Control	**Memo**	0.00				100	ϕ		BC 12.04.04
120	QC8- Inspect parts - second check	0.00							
120 QC Quality Control	**Memo**	0.00							12.04.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3492-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Plug
Start Date: 21/03/2012 **Start Qty:** 100.00 *100*
Required Date: 04/04/2012 **Req'd Qty:** 100.00 *100*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				100	BL	12-4-5	
	Memo	0.00							
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				100	DP	12/04/06	
	Memo (Flat End Only) START TIME: 9h15 OVEN TEMPERATURE: 320°F FINISH TIME: 9h45	0.00							
150 *150* QC Quality Control	QC3- Inspect Part Finish	0.00				100	BL	12-4-9	
	Memo	0.00							

M120222

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3492-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Plug
Start Date: 21/03/2012 **Start Qty:** 100.00 *100* **Cust Item ID:**
Required Date: 04/04/2012 **Req'd Qty:** 100.00 *100* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: FP-A	0.00							
160									
Packaging	**Memo**	0.00							
Packaging									

100x ¢ MH 12/04/09

170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00							
Quality Control									

12/4/10 JH

MF 12-04-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:50:36 PM

Work Order ID: 81967

81967

Parent Item: D3492-3

D3492-3

Parent Item Name: Plug

Start Date: 21/03/2012 **Required Date:** 04/04/2012

Start Qty: 100.00 **Required Qty:** 100.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	50.0430	0.06	6.315789			

M6061T6R0.750

6061-T6 Round Bar .750"

**

Location	Loc Qty	Loc Code
MAT012	50.043	
~~120603~~	2.043	
120734	48	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

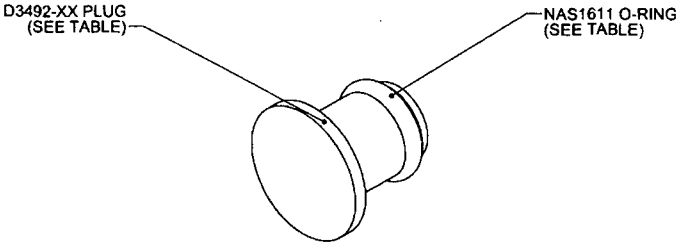
DART AEROSPACE LTD	Work Order:	81967
Description: Plug	Part Number:	D3492-3
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	.746	✓		Dial Caliper	BG 05
Ø0.582	+0.008/-0.001	.581	✓			
0.045	+0.000/-0.002	.044	✓			
0.060	+/-0.005	.060	✓			
0.060	+/-0.005	.060	✓			
0.500	+/-0.010	.500	✓			
0.090	+0.000/-0.002	.088	✓			

Measured by:		Audited by:		Preliminary Approval:	
Date:	12 Jan 07	Date:	12.04.07	Date:	

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue P/O D3492-043	KJ/JLM	
B	06.10.16	Ø0.750 was Ø0.625	KJ/JLM	
C	08.09.04	Tolerance revised for Ø0.750	KJ/DD	
D	11.06.21	Dwg Rev updated	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81967MLJ
12/03/21

RELEASED
2011 -05- 30

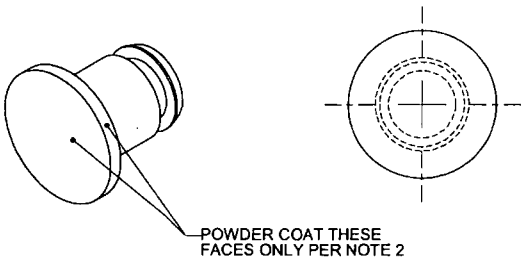
D3492-XXX PLUG PARTS LIST

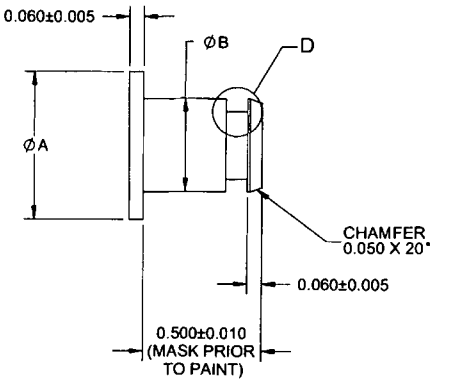
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

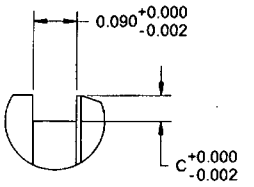
REV.	DESCRIPTION	BY	DATE
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3492	REV. D
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE PLUG	SCALE 2:1
DE APPR.			
DATE 11.05.24			





D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	D
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	D

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

RELEASED
2011 -05- 30

DESIGN	PH	DART AEROSPACE LTD
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3492 REV. D
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE PLUG SCALE 4:1
DE APPR.		
DATE	11.05.24	